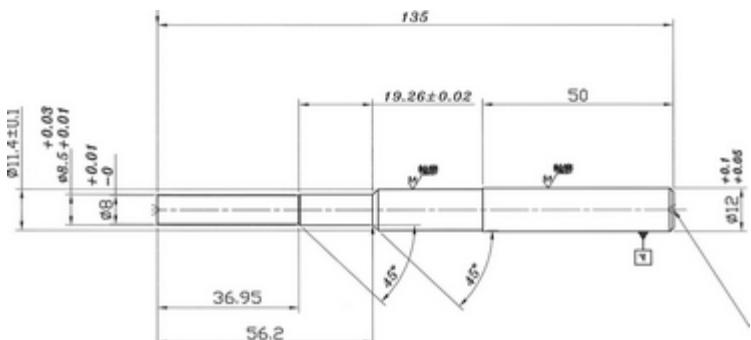


Stepreamer Ø8-Ø8.5-Ø11.4

A15-200

This tool is basically not a finished tool, it is the shank before soldering of PKD inserts. The OD grinding was done before on a cylindrical grinding machine.



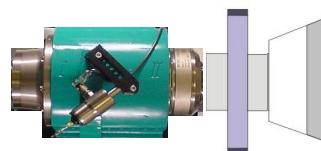
1. Cycletime for Production

Workpiece:	end-Ø8, Ø8.5, Ø11.4, shank-Ø12.1 mm, Z 2, Length 82 mm, Helix angle 0° Material CARBIDE					
Operations	Probe	Flute 1	Flute 2	O.D.3	O.D.2	O.D.1
Feed [mm/Min]	2000	30	60	45	30	60
Power [kW]		2	1	1	1	1
Cutting speed [m/s]		20	20	22	22	22
Used wheels		1	1	2	2	2
Grinding time [s]	9	353	177	194	287	149
Total cycle time	19 Min 29					

The cycle times are indicative. Material to be ground, grinding wheels, coolants can influence the cycle times considerably.

2. Used Grinding Wheels

1	1A1 Ø60 D126
2	11V9 Ø100 D76



1 2

3. Machine and Software Requirements

Machines: 5 axes CNC grinders : GEMINI DMR

Coolant: Synthetic Oil, pressure 6 bar

Control: Fanuc 31iA5

Software: Quinto 5

Accessories:

Responsible engineer: OP. 28.2.13

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TECHNOLOGY
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